

Work Order ID 61010

August 4, 2010 8:56:01 AM



Page 1

Item ID: D4149-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 8/04/10

Start Qty: 10.00



Cust Item ID:

Required Date: 8/11/10

Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-8-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4149

B

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

10.8.12

10

φ

Jeaspa Bandsaw

4.00" LONG

110

0.00



HAAS 1

Memo

0.00

L.A 10/08/14

10

φ

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA942 AND DWG

FOLIO REV: AA

DWG REV: B

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

G.A 10/08/14

10

0

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

10/08/14

10

0

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 123

0.00

10/11/16 102 sf

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
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Page 3

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Required Date: 8/11/10

Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/08/10

CZ 10/8/10

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NOTE: Date & initial all entries

Picklist Print

August 4, 2010 8:56:05 AM

Page 1

Work Order ID: 61010



Parent Item: D4149-3



Parent Item Name: Spacer

Start Date: 8/04/10

Required Date: 8/11/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000		Purchased	No			110	f	2.7402	0.33333333	3.333333			



303 BAR 1" X 1"

Location	Loc Qty	Loc Code
rf 10-8-12 MAT53	2.74022	
113341	1.51126	
113719	1.22896	

3.33

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

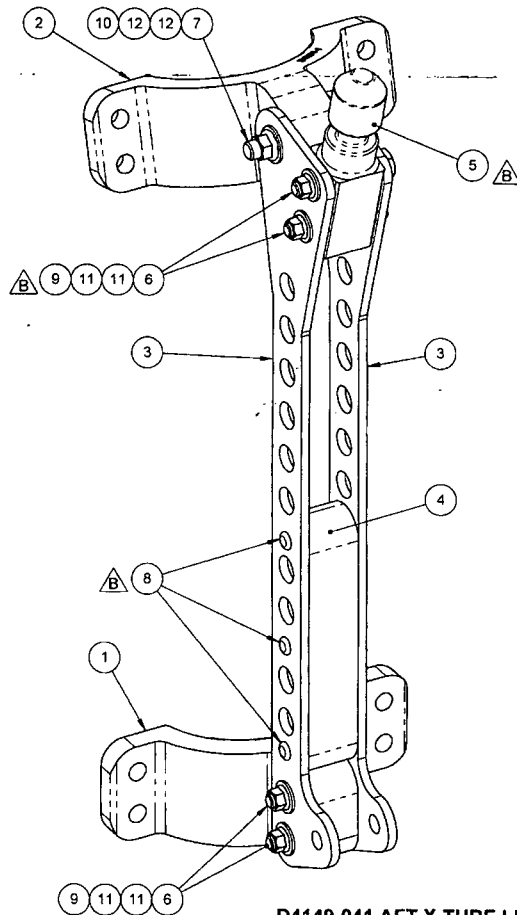
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NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.17 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	4	AN3C12A	
7	1	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	4	MS21043-3	NUT
10	1	MS21043-4	NUT
11	8	NAS1149C0332R	WASHER
12	2	NAS1149C0432R	WASHER

SHOP ONLY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 61010
10-8-09

RELEASED
 2010-07-16
MB

B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.05		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4149** REV. B
 SHEET 1 OF 5

TITLE **AFT X-TUBE LUG ASSY** SCALE NTS

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

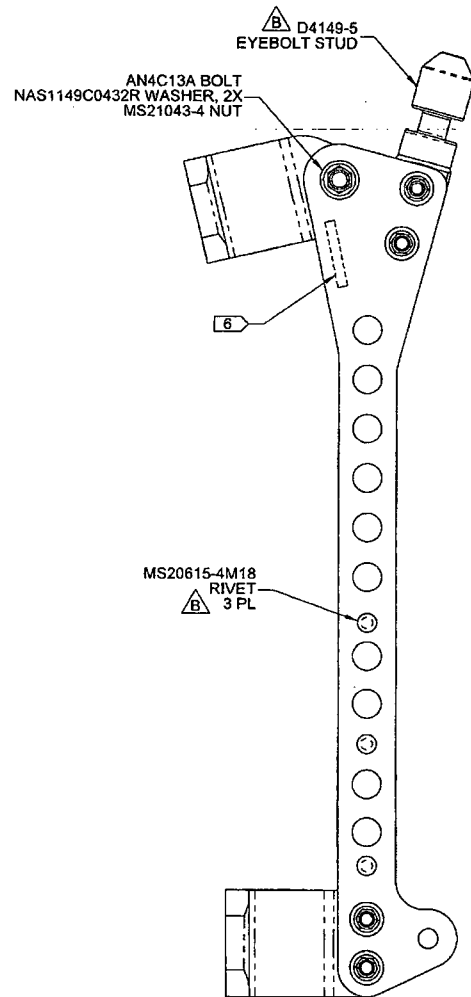
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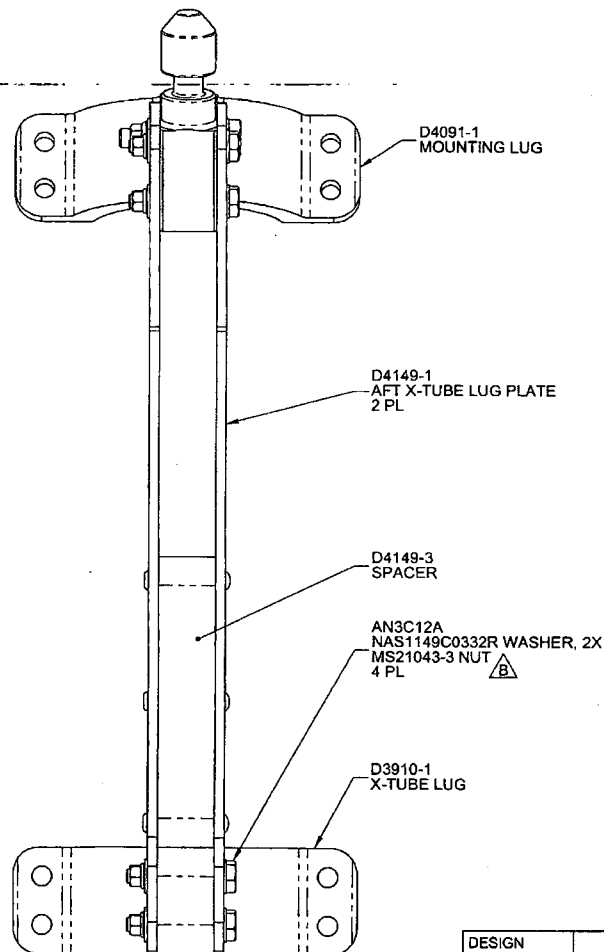
C

B

A








D4149-041 AFT X-TUBE LUG ASSY



wlb 610 10

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2010-07-16
MD

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MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	10.07.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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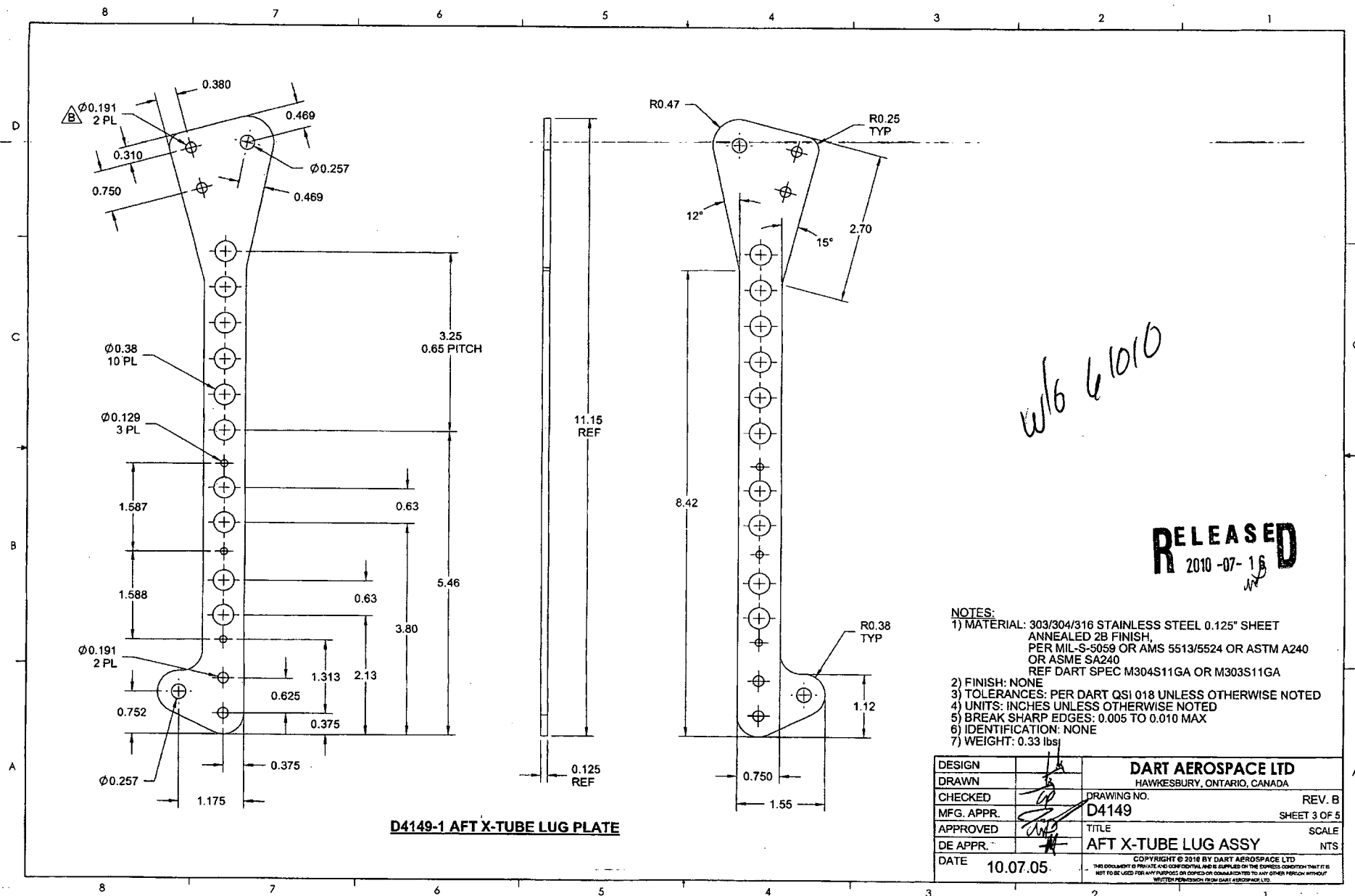
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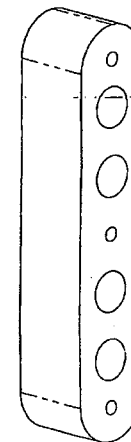
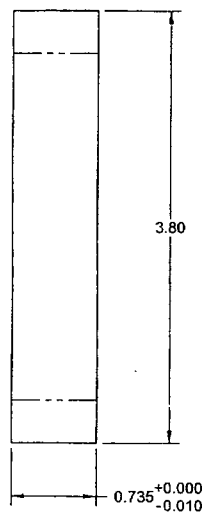
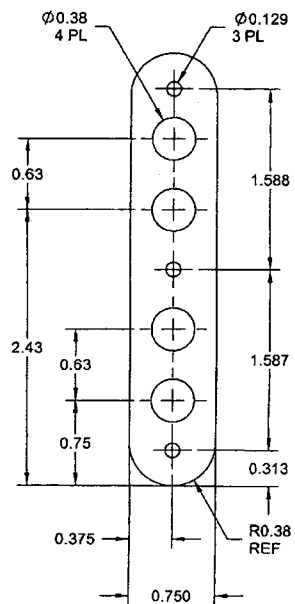
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NOTE: Date & initial all entries



D4149-3 SPACER

w/b 41010

RELEASED
2010-07-16
JMT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
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MFG. APPR.			D4149	SHEET 4 OF 5
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DE APPR.			AFT X-TUBE LUG ASSY	NTS
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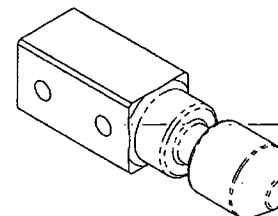
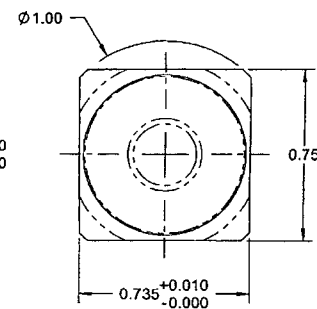
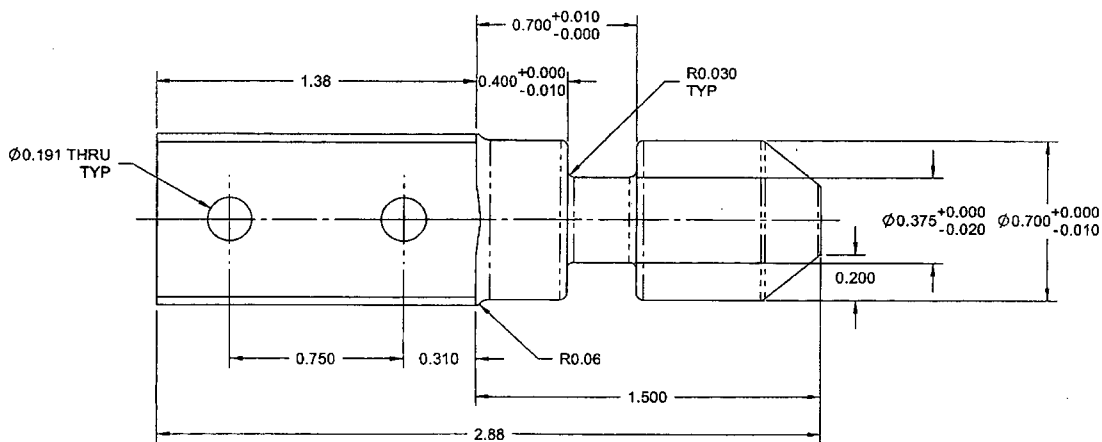
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4149-5 EYEBOLT STUD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.33 lbs

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2010-07-16

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